

Date: Wednesday, 12/20/2006 11:59:20 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : WEB
 Job Number : 29997
 Estimate Number : 10498
 P.O. Number : N/A
 This Issue : 12/20/2006 S.O. No. : N/A
 Prsht Rev. : NC
 First Issue : N/A Type : LANDING GEAR
 Previous Run : 29977
 Written By :
 Checked & Approved By : 061220
 Comment : Est Rev: C 02.11.28 Reformat KJ
 Est Rev: D 06-03-21 As Per Rev C JLM

Part Number : D2739
 Drawing Number : D2739 REV C
 Project Number : N/A
 Drawing Revision : C
 Material : N/A
 Due Date : 12/29/2006 Qty: 4 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D26005108 Extrusion 'I Beam' thin



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Extrusion 'I Beam' thin

Pick:

Qty Part Number Description Batch

1 D2600-5 Web ~~B2446~~ B24410 Pmc/R 07-01-23

2.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Cut D2600-5 to length as per Dwg D2739. Pmc/R 07-01-23

2-Drill pilot holes in web using drilling Jig DT8162 as per Dwg D2739. Pmc/R 07-01-23

3-Use uni-bit to open holes to finish size as per Dwg D2739. Pmc/R 07-01-23

4-Bevel Fwd ends (1" max) of extrusion and Deburr holes and ends. Pmc/R 07-01-23

5-Deburr Pmc/R 07-01-23

3.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

DP 7-1-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
20							

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: L Date: 07/01/29
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: WEB

Job Number: 29997

Part Number: D2739

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

BE 106 7-1-34 (4)

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Pm 07-01-26 (4)

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Use a red or black lead-free paint pen to write the part number and batch number in the middle of each web.

Identify and Stock

Location: LG

Pm 07-01-26 (4)

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/01/09

Job Completion



07-01-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

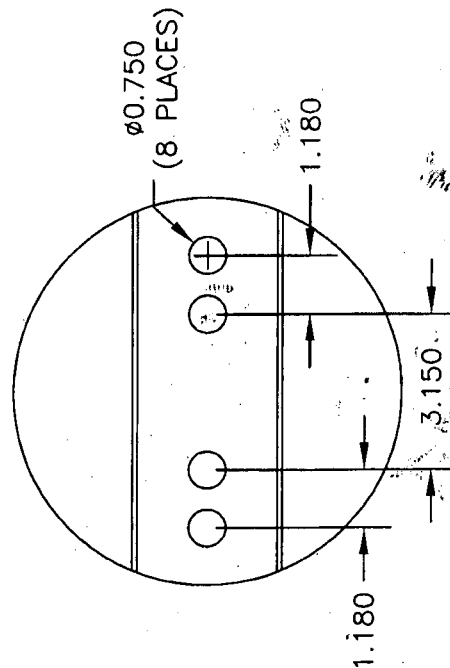
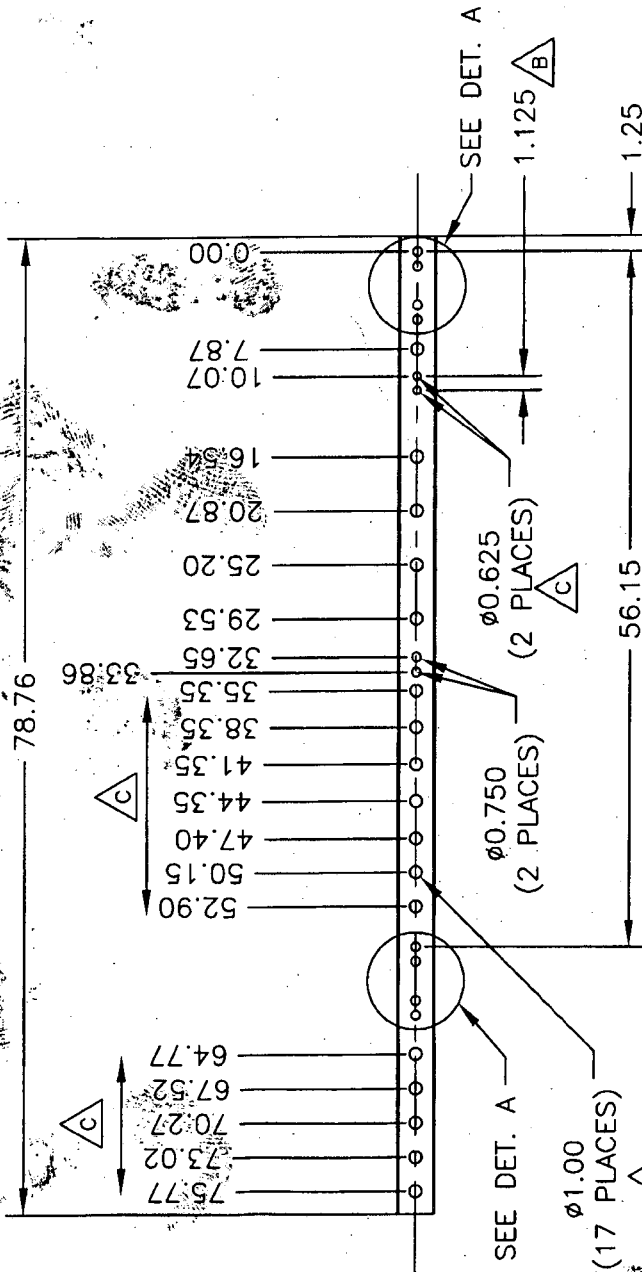
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART**RELEASED**
06-02-07

DESIGN RH	DRAWN BY RH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED H	APPROVED H	DRAWING NO. D2739	REV. C SHEET 1 OF 1
DATE 06.01.05	TITLE WEB	SCALE 1:15	
A	98.04.16	NEW ISSUE	
B	98.11.18	CHANGE HOLES FOR COMPATABILITY WITH AIRCRUISER FLOATS	
C	06.01.05	ADD/MOVE HOLES FOR COMPATABILITY W/APICAL FLOATS	



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 2999.7

- D2739 WEB
- MATERIAL: MAKE FROM D2600-5 EXTRUSION
ACID ETCH, ALODINE PER DART QSI 005 4.1
- FINISH: 2) ALL DIMENSIONS ARE IN INCHES
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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